

5/16

DART AEROSPACE LTD	Work Order:	22811
Description: 206 L/L-1/L-3/L-4 HighGear Web 04.08.17 04.08.17 QP	Part Number:	D2654-7
Drawing: D2654 Rev. D # E1	Qty:	6

Step	Location	Procedure	By	Date
1	EXPEDITING	Issue Work Order	KD	05/03/28
2	METAL	Pick: Qty Part Number Description Batch 1 D2600-7 Web B2130	BE	05/04/14
3	METAL	Cut D2600-7 to length as per Dwg D2654 (116.00) 04.08.17 04.08.17	BE	05/04/14
4	METAL	Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654	BE	05/04/14
5	METAL	Using the uni-bit, open holes to finish size as per Dwg D2654	BE	05/04/14
6	METAL	Deburr holes and ends	BE	05/04/14
7	METAL	Acid Etch and Alodine as per QSI 005 4.1	BE	05/04/14
8	QC	Inspect Level 5	J	05.04.14
9	METAL	Identify and stock	SP	05/04/14
10	EXPEDITING	Close Work Order Cost/part: 38.45 546 05/04/19 (6)	JB	05.04.14

Rev	Date	Change	Revised By	Approved
A	97.07.30	New Issue	JB	
B	97.08.28	Change part No. Step 1 & 2	KS	
C	98.09.14	Re-format, drawing rev.	CS	
D	99.02.04	Fixed typo, Changed procedure	DM	(S)

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9- 89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

RELEASED
AM 99.02.19

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr		Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____

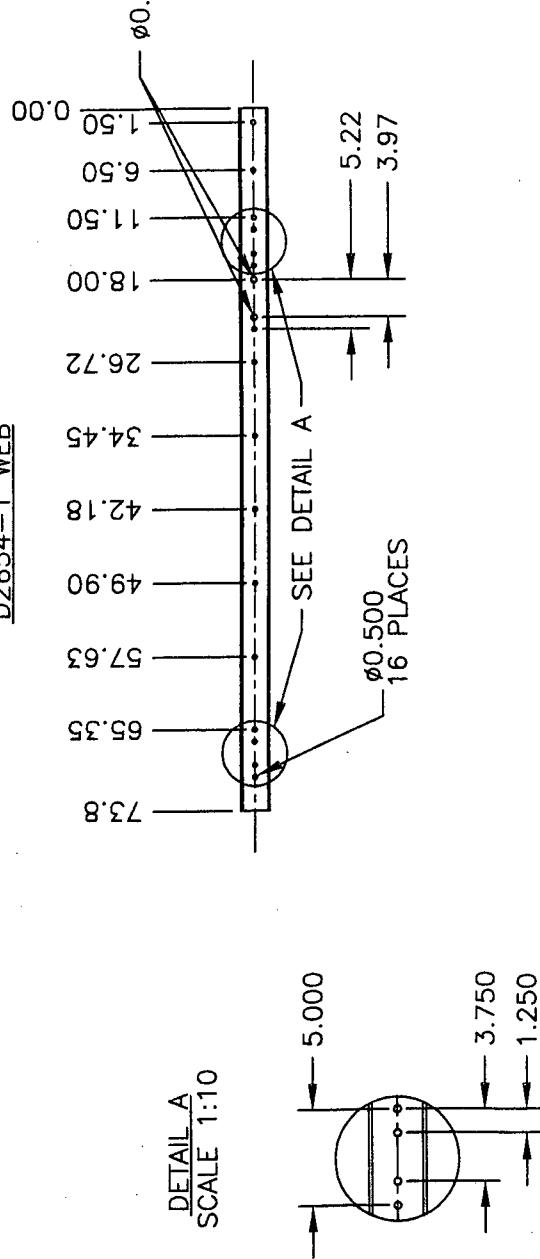
Date: _____

DART

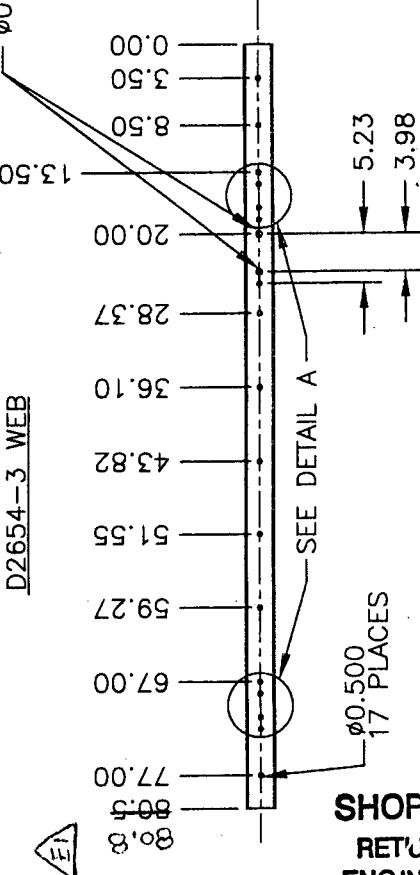
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE		TITLE WEB
04.05.26		SCALE 1:20
A	97.03.25	NEW ISSUE
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438
C	97.10.29	CHANGED HOLE PATTERN
D	98.01.15	GHW HOLES CHANGED TO Ø0.63
E	04.05.26	CHANGE LENGTHS, REFORMAT
E1	04.08.24	PER TOOLING; 80.8 WAS 80.5

RELEASED
04.06.22

D2654-1 WEB



D2654-3 WEB



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WORK ORD.

NO. Z2811

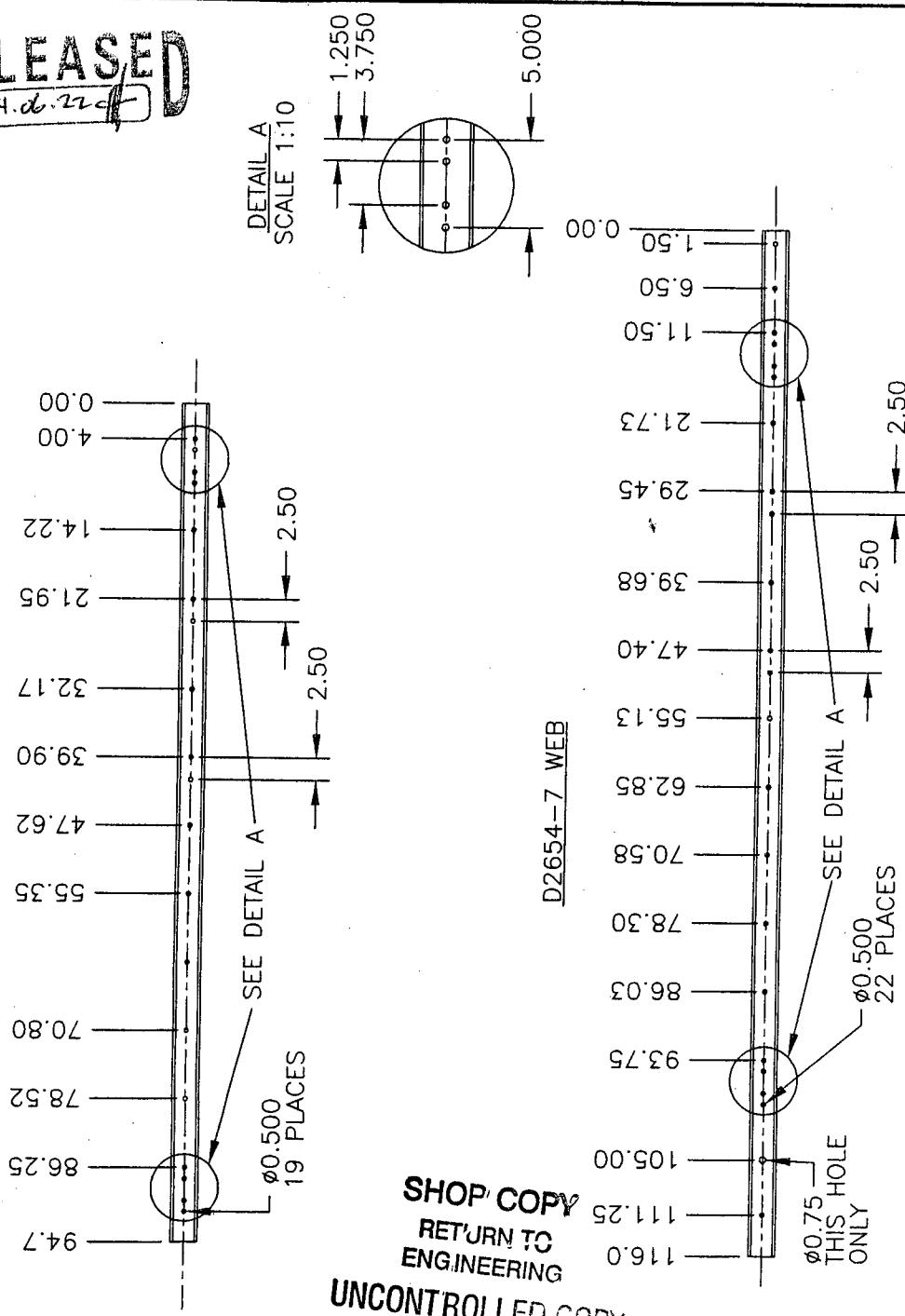
MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DARTOR COPY
3/26

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654
DATE		REV. E SHEET 2 OF 2 SCALE 1:20
04.05.26		TITLE WEB

RELEASED
04.05.22D2654-5 WEB

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WORK C

NO. 22811

MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Job Costing Report

Dart Aerospace Ltd.
HawkesburyMar 23, 2005
07:09 am

Work Order No : 0022811
 Project Name : D2654-7
 Project For : WK516
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2654-7
 Description : 206 I Beam (Web)
 Manufactured : Yes
 Amount Req'd : 6
 Amount Done : 0
 Start Date : 03-22-05
 Est Finish Date : 04-22-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden :	0.00	0.00	0.00	0.00	0.00
<hr/>					
Total Cost :	0.00	0.00	0.00	0.00	0.00
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00